

core mold having a pair of ejector pins arranged therein for forceably separating said movable core mold from said first molten resin flow path;

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a second molten resin flow path arranged proximate to said movable core mold, said second molten resin flow path being accessible to said first molten resin flow path by operation of an adjustable pressure valve arranged for alternately blocking and unblocking molten resin flow between said first molten resin flow path and said second molten resin flow path to accommodate a change in molding cavity pressure associated with a change in molten resin material introduced into said injection molding machine, said adjustable pressure relief valve being located on said mold parting line proximate to said first molten resin flow path and said second molten resin flow path, wherein said adjustable pressure relief valve being disposed to retain molten material in said first molten resin flow path when the molding cavity pressure is less than a predetermined level and, to release molten resin material from said first molten resin flow path into said second molten resin flow path when molding cavity pressure exceeds said predetermined valve.

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